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NS1

Stop *NS2*

20

Start Date: 10/13/2016 **Start Qty:** 20.00

Required Date: 10/18/2016 **Req'd Qty:** 20.00

20

Customer:

Run Start *NR1*

Date: SEP 26 2016 Tooling:

Date: _____

QC: 9-89-33

Date: _____ **SPC (Y/N):** _____

Date: _____

Stop *NR2*

Draw Nbr	Revision Nbr
D2278	Rev F

0.00

FLOW WATER JET

0.30

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D2278 Dwg Rev: F Prog Rev: F 2-
Deburr if necessary

0.00

QC2- Inspect parts off machine FAI/FAIB

0.03

QC

Memo

Quality Control

0.00

QC8- Inspect parts - second check

0.07

OC

Memo

Quality Control

Work Order ID 151379

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Item ID: D2278 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Leg
Start Date: 10/13/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 10/18/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130 HandFinish Hand Finishing	Memo	0.07				(X20)	✓		2016/09/30 BEB
140	QC7-Inspect Chemical Conversion Coat	0.00							
140 QC Quality Control	Memo	0.03				(20)			SEP 30 2016 38 9-89
150	Identify as per dwg & Stock Location: _____	0.00							
150 Packaging Packaging	Memo LOCATION: GA	0.03				20X			OCT 04 2016 DAS 26 9-89

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Item ID: D2278 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Leg
Start Date: 10/13/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 10/18/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.33							
Quality Control									

OCT 05 2016

**DAS
21
9-89**

OCT 05 2016

Picklist Print

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Work Order ID: 151379

151379

Parent Item: D2278

D2278

Parent Item Name: Step Leg

Start Date: 10/13/2016

Required Date: 10/18/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now 6061-T6 06-06-23 JLM
IPP Rev C New flat pattern 08.01.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080		Purchased	No			100	sf	176.9000	0.9815	20.66316			
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M6061T6S 080

oc 16/09/29

6061-T6 .080 Sheet

Location	Loc Qty	Loc Code
MAT020	176.9	
134217	9.1	
m132772	4.3	
m133587	7.7	
m133828	2.6	
m134551	7	
m134830	21.9	
m135147	21.9	
m135377	8.1	18
m135559	94.3	

M6061T6S.080
M135377

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151375 M.C.
1609-26

RELEASED
6.01.10 W.P.

D2278 LEG

NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.080) OR 5052-H32 ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/8 OR AMS 4016) (REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

F	CHANGE Ø0.213 HOLES TO Ø0.213 X 0.750 SLOT CHANGE SOME DIMENSIONS TO X.XX FROM X.XXX UPDATE PROFILE AND FORMAT, REF NCR 263	PH	07.12.27
E	ADD 6061-T6 MATERIAL	CB	06.05.29
D	ADD FINISHING NOTE	PH	05.11.14
C	CHANGED RADIUS TO 0.354	BW	95.02.16
B	CHANGED TO MATCH SPACERS	BW	94.11.08
A	NEW ISSUE	BW	94.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Ref</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>Ref</i>		
CHECKED	<i>Ref</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>Ref</i>	D2278	SHEET 1 OF 1
APPROVED	<i>Ref</i>	TITLE	SCALE
DE APPR.	<i>Ref</i>	LEG	3:2
DATE	07.12.27	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	